

Work Order ID 86474

June-29-12 1:30:00 PM

86474

Page 1

Item ID: D4543-4

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, Outer, RH

Start Date: 29/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 17/06/29

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4543	A

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100

Waterjet

Memo

FLOW CNC Waterjet

1- Cut as per dwg

Prog rev: A

Dwg rev: A

6061 .032

2- Deburr

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110

QC

Memo

Quality Control

0.00

10 0 Im 12-7-9

10 0 Im 12-7-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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June-29-12 1:30:00 PM

Page 3

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 29/06/2012 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 13/07/2012 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 157

0.00

170

Packaging

Memo

0.00

Packaging

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Page 4

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Start Date: 29/06/2012 Start Qty: 10.00

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Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00


180

QC

Memo

0.00

Quality Control

12/7/18 ME
12-07-18

W/O:		WORK ORDER CHANGES					
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Picklist Print

June-29-12 1:30:03 PM

Page 1

Work Order ID: 86474

86474

Parent Item: D4543-4

D4543-4

Parent Item Name: Retainer, Outer, RH

Start Date: 29/06/2012

Required Date: 13/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP revA 12.01.12 New Issue EC verified by:DD
REV:B 12.02.24 as per dwg reva DD verf:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	247.7760	1.144	12.04211			

M6061T6S 032

**

12.1

Jan 12-7-8

6061-T6 Sheet 0.032"

Location

Loc Qty

Loc Code

MAT021

247.776

118106

46.136

120218

20.13

120285

42.24

121099

139.27

122311

122311

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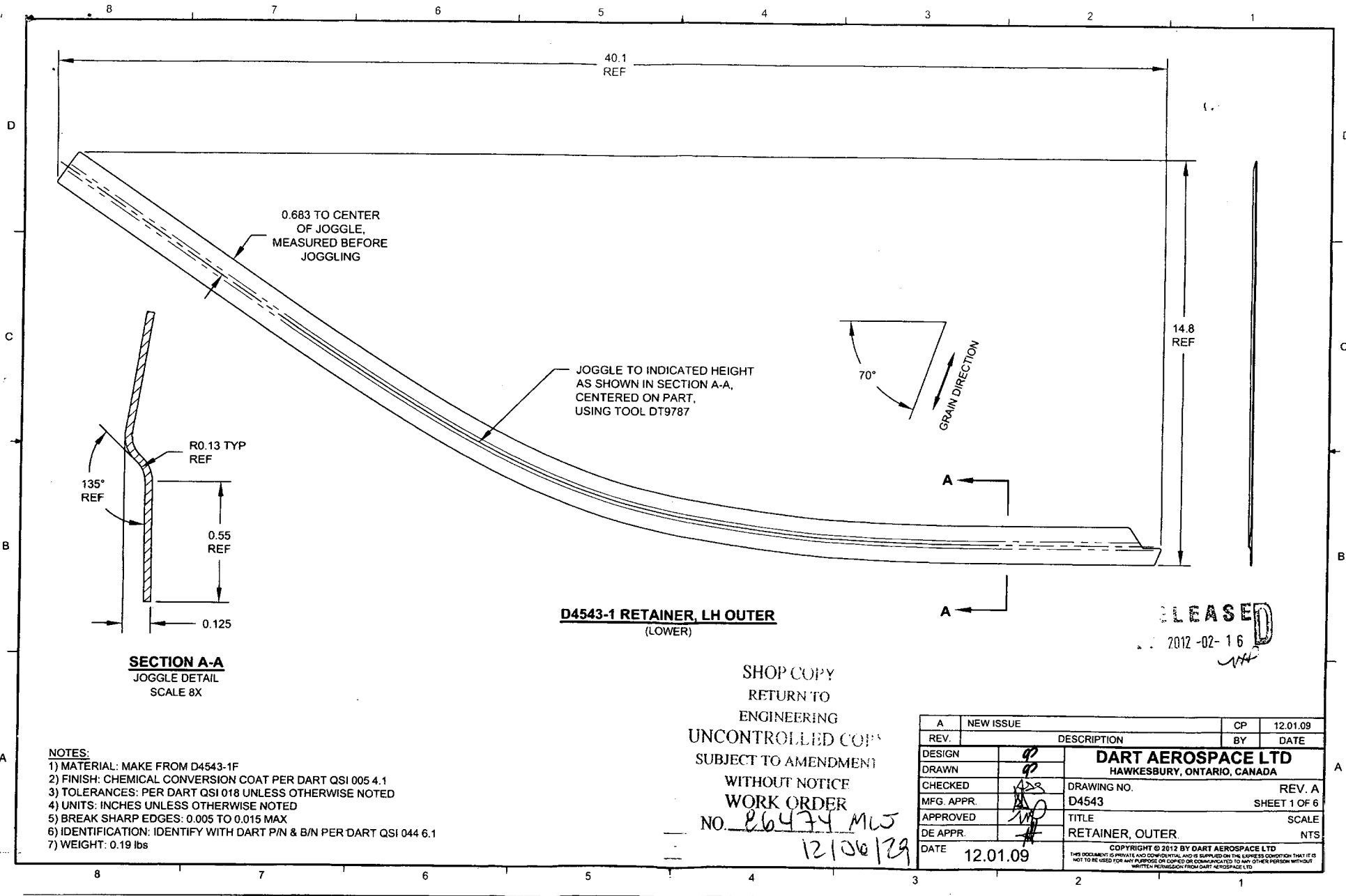
Dart Aerospace Ltd

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NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: MAKE FROM D4543-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.19 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26474 MLJ
12/06/29

A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.01.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D4543 SHEET 1 OF 6
TITLE SCALE
RETAINER, OUTER NTS

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2012-02-16

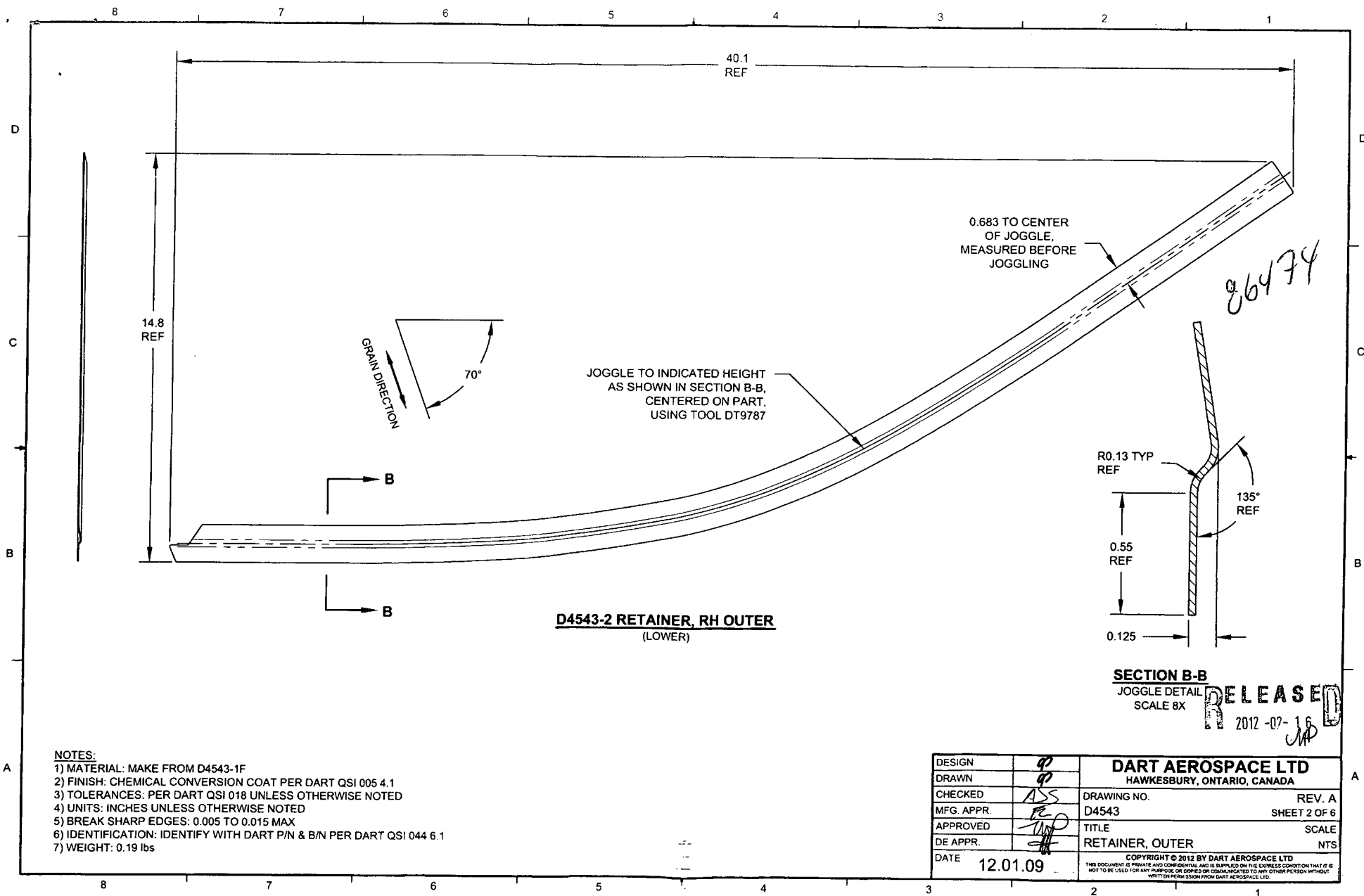
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.19 lbs

DESIGN	<i>Q</i>	DART AEROSPACE LTD	
DRAWN	<i>Q</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>FE</i>	D4543	SHEET 2 OF 6
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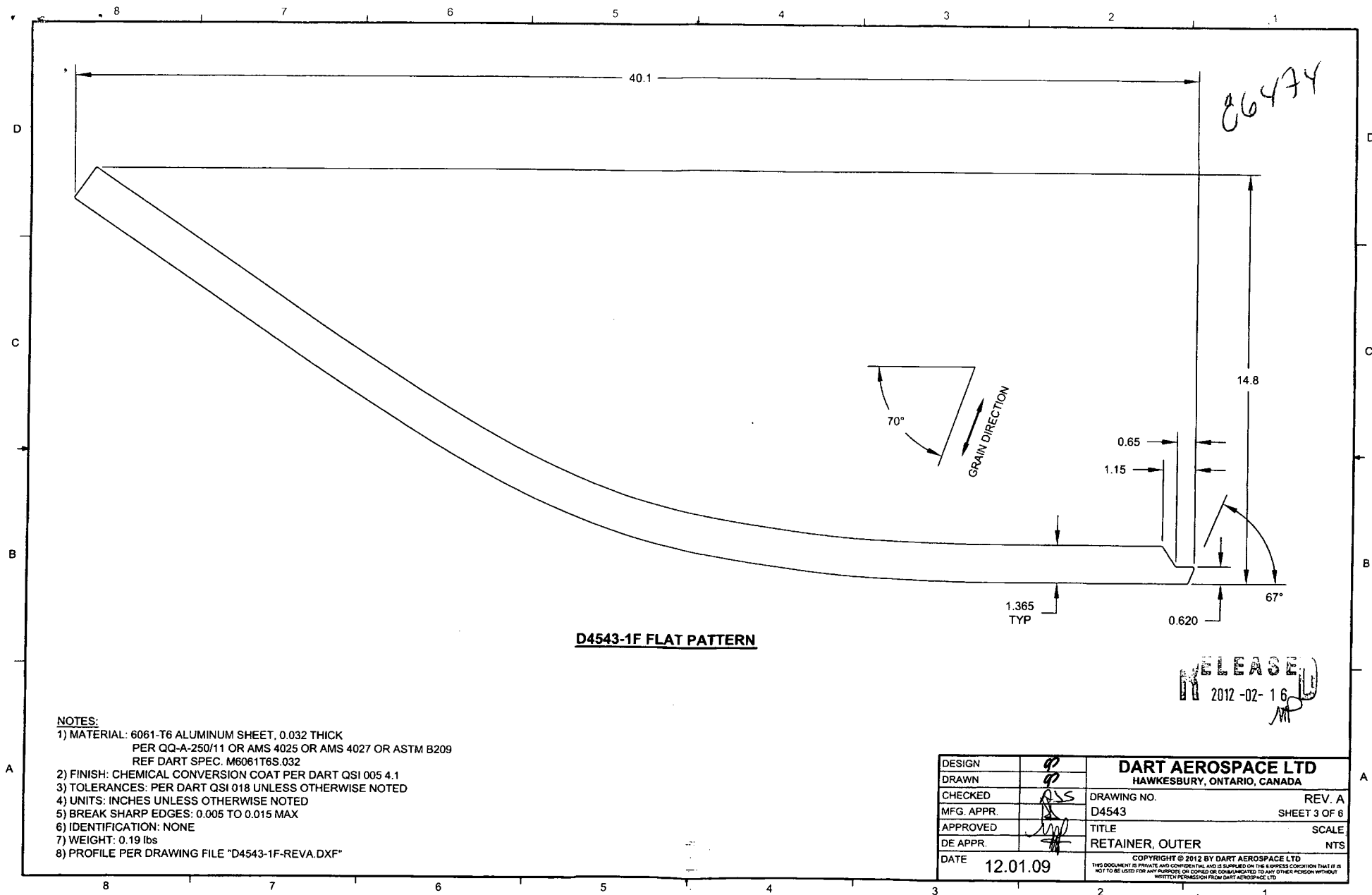
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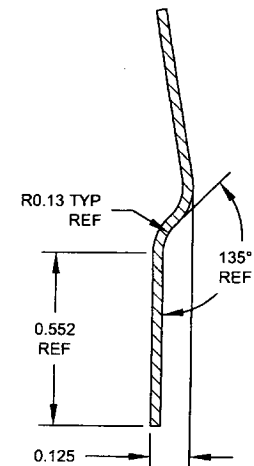
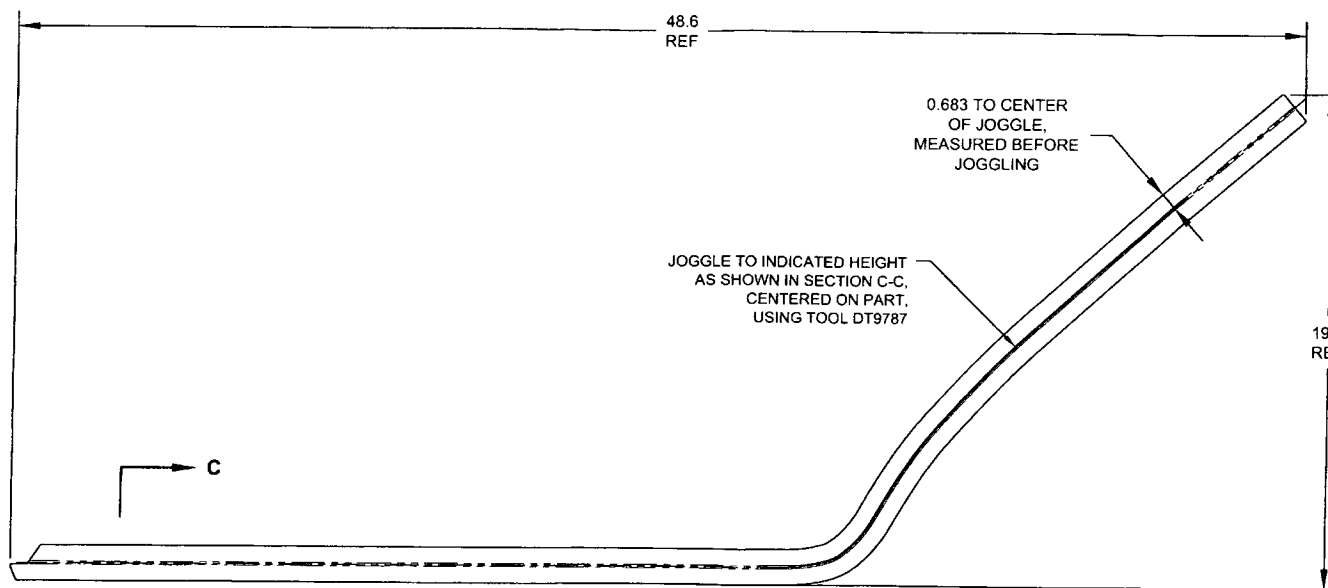
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86474



SECTION C-C
JOGGLE DETAIL
SCALE 12X

D4543-3 RETAINER, LH OUTER
(SIDE/TOP)

NOTES:

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4543	SHEET 4 OF 6
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2012-02-16

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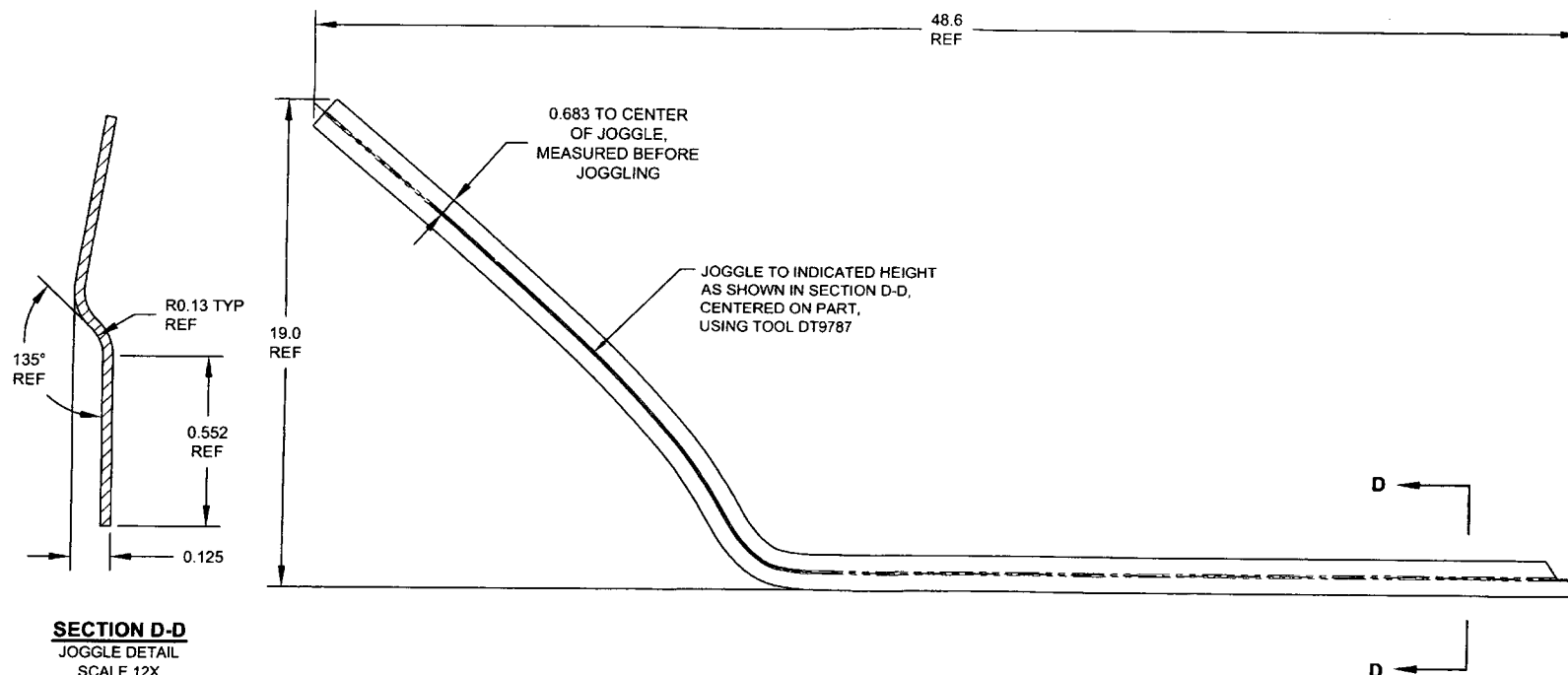
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86474



D4543-4 RETAINER, RH OUTER
(SIDE/TOP)

RELEASED
2012-02-16

NOTES:

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN	<i>Q</i>	DART AEROSPACE LTD	
DRAWN	<i>Q</i>	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>[Signature]</i>	D4543	SHEET 5 OF 6
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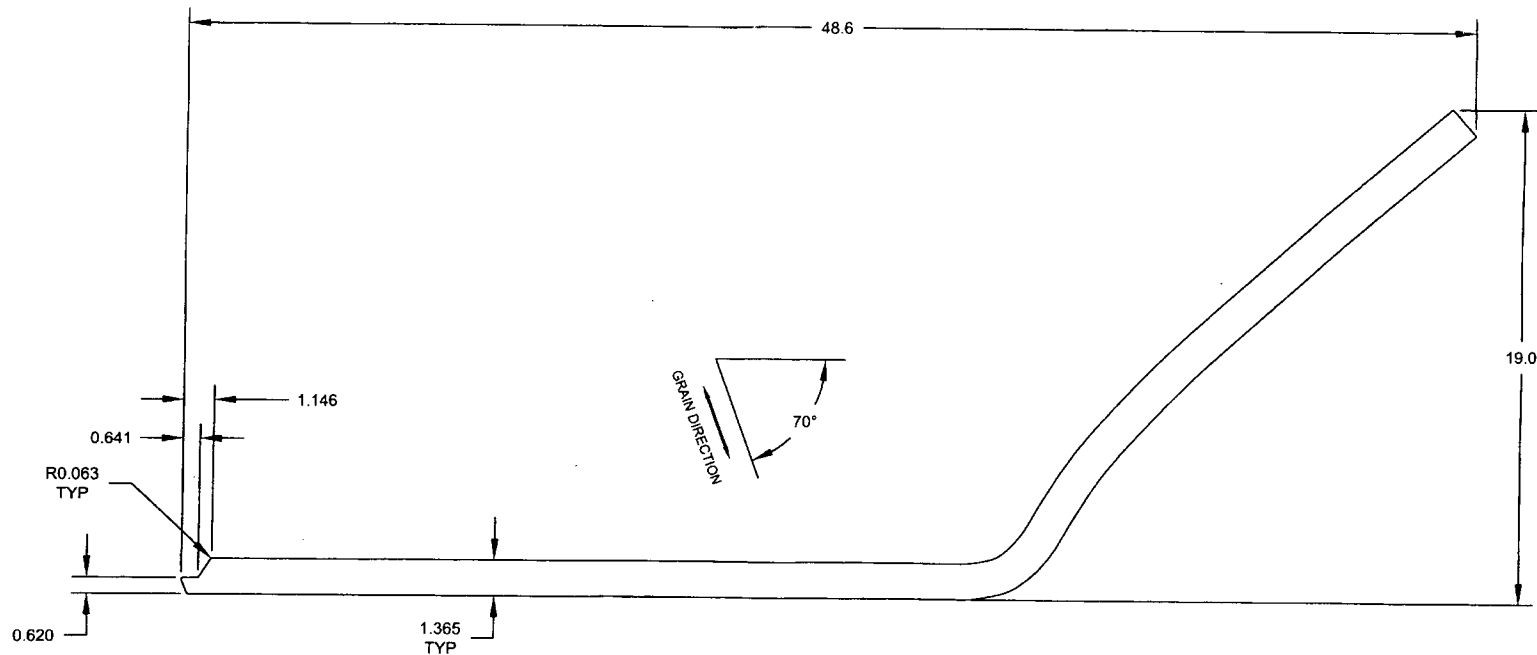
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26474



D4543-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-3F-REVA.DXF"

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2012-02-16

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DRAWN	<i>Q</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.		D4543	SHEET 6 OF 6
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